

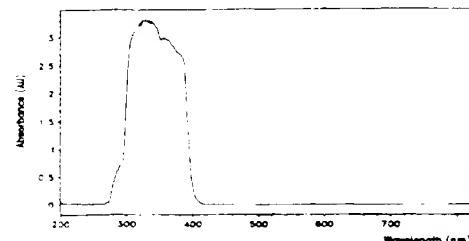
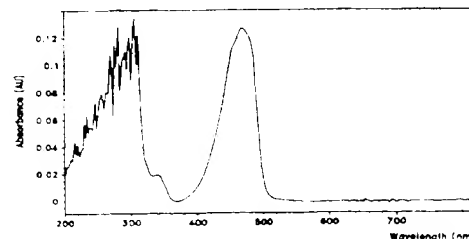
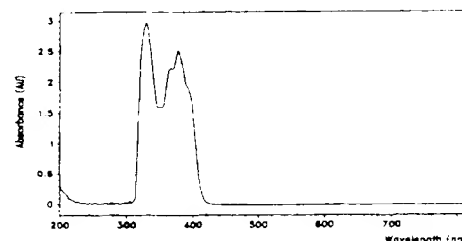
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(71) Applicant: <b>ALCON LABORATORIES, INC. [US:US]; 6201 South Freeway, Fort Worth, TX 76134-2099 (US).</b>		
(72) Inventors: <b>LEBOEUF, Albert, R.; 7861 Mahonia Drive, Fort Worth, TX 76133 (US). KARAKELLE, Mutlu; 6713 Glen Meadow Drive, Fort Worth, TX 76132 (US).</b>		
(74) Agents: <b>RYAN, Patrick, M. et al.; Alcon Laboratories, Inc., 6201 South Freeway, Fort Worth, TX 76134-2099 (US).</b>		

**(54) Title:** METHOD OF PREPARING FOLDABLE HIGH REFRACTIVE INDEX ACRYLIC OPHTHALMIC DEVICE MATERIALS**(57) Abstract**

Foldable, acrylic, high refractive index ophthalmic device materials containing a UV absorbing chromophore are cured by exposure to blue light using a benzoylphosphine oxide photoinitiator.



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# METHOD OF PREPARING FOLDABLE HIGH REFRACTIVE INDEX ACRYLIC OPHTHALMIC DEVICE MATERIALS

## FIELD OF THE INVENTION

5 This invention relates to photopolymerizable acrylic ophthalmic device materials. In particular, this invention relates to the use of benzoylphosphine oxide initiators in blue-light curing of foldable acrylic ophthalmic device materials.

## BACKGROUND OF THE INVENTION

10 The two most common types of polymerization initiators for ophthalmic device materials are thermal initiators and photoinitiators. Typical thermal initiators, including free radical initiators such as peroxides, initiate polymerization as temperature is increased. In some cases, two or three temperature tiers are  
15 involved such that curing involves a schedule of temperature/time combinations. Thermal initiation generally requires holding the monomer composition at elevated temperatures for lengthy periods of time. Total cure times of twenty-four hours are not unusual. See, for example, U.S. Patent No. 5,290,892.

20 Photoinitiators generally offer the advantage of relatively short cure times and, unlike thermal initiators, can be used at ambient conditions, eliminating the need for high-temperature equipment or special ovens. Photoinitiators are activated by light of one or more specified wavelengths, rather than heat.  
25 Photoinitiation of ophthalmic lens materials is known. See, for example, U.S. Patent No. 5,290,892.

30 The most common types of photoinitiators known or used for curing ophthalmic lens polymers are probably UV-sensitive photoinitiators. UV-sensitive photoinitiators are, however, generally not suitable for use with lens materials that contain a UV-absorbing chromophore. UV-absorbing chromophores present in an ophthalmic lens composition can interfere with the ability of UV-sensitive

photoinitiators to efficiently cure the composition. Today, UV-absorbing chromophores are frequently incorporated in ophthalmic lens materials in order to reduce or block UV light from reaching the retina. Although methods are known for temporarily "blocking" UV absorbing chromophores during processing, thereby preventing interference with a UV-initiator, these methods require that the UV-absorber be "un-blocked" after the composition is cured. The UV chromophore can be "un-blocked" by either chemical or thermal means. "Un-blocking" is generally complicated and can add 4 - 6 hours to processing times, offsetting some or all of the time advantages offered by photoinitiators.

In addition to UV-sensitive photoinitiators, visible-light initiators are also known. For example, U.S. Patent No. 5,224,957 discloses photopolymerizable compositions useful in forming an intraocular lens in situ. The compositions are delivered into the natural lens capsule or a thin plastic shell substitute and then polymerized. The reference compositions contain 90 - 99.99% by weight of at least one polyfunctional acrylic and/or methacrylic acid ester. Suitable acid esters include bisphenol A or bis(hydroxy)polyalkoxy bisphenol A derivatives lengthened with ethylene oxide or propylene oxide.

The compositions of the '957 patent are cured using photoinitiators which absorb light in the range 400 - 500 nm. Suitable initiators include alpha-diketones, in particular camphorquinone, benzil and phenanthrene quinone, and mono and bisacylphosphine oxides. According to the '957 patent, particularly preferred initiators are "for example 2,4,6-trimethylbenzoyldiphenylphosphine oxide and bis-(2,6-dichlorobenzoyl)-4-n-propylphenylphosphine oxide or bis-(2,6-dichlorobenzoyl)-4-n-butylphenylphosphine oxide" (see Col. 3, lines 12-16).

International Patent Application Publication No. WO 96/28762 also discloses photocurable compositions comprising acrylic components. The compositions contain specified amounts of di(meth)acrylates, poly(meth)acrylates, urethane(meth)acrylates, and oligomeric di(meth)acrylates based on bisphenol A or bisphenol F. The photoinitiator may be "any photoinitiator which forms free radicals

when irradiated suitably." Suitable classes include benzoin ethers; acetophenones; benzil; anthraquinones; benzoylphosphine oxides (e.g., 2,4,6-trimethylbenzoyldiphenylphosphine oxide); benzophenones. Photoinitiators particularly suitable for use with argon ion lasers include 2,4,6-trimethylbenzoyldiphenylphosphine oxide.

## SUMMARY OF THE INVENTION

The present invention relates to methods for preparing foldable acrylic, high refractive index ophthalmic device materials that contain a UV-absorbing chromophore and a benzoylphosphine oxide photoinitiator. The methods comprise activating the benzoylphosphine oxide photoinitiator with a blue-light source.

Among other factors, the present invention is based on the finding that foldable, acrylic, high-refractive index ophthalmic device materials that contain a UV absorber are effectively cured using a blue light source and the benzoylphosphine oxide initiator, 2,4,6-trimethyl-benzoyldiphenylphosphine oxide. In contrast, when camphorquinone, which has a greater absorbency in the blue-light region than 2,4,6-trimethyl-benzoyldiphenylphosphine oxide, is used in place of the benzoylphosphine oxide initiator, the same ophthalmic device materials are not efficiently cured.

## BRIEF DESCRIPTION OF THE DRAWINGS

Figure 1 shows a sample UV-visible spectrum of the benzoylphosphine oxide initiator 2-4-6- trimethylbenzoyldiphenylphosphine oxide in a 2-phenylethyl acrylate solvent.

Figure 2 shows a sample UV-visible spectrum of the alpha-diketone initiator camphorquinone in a 2-phenylethyl acrylate solvent.

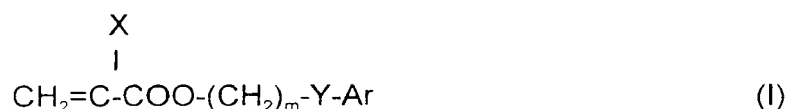
Figure 3 shows a sample UV-visible spectrum of the UV chromophore 2-(3'-

methallyl-2'-hydroxy-5'-methylphenyl)benzotriazole in a 2-phenylethyl acrylate solvent.

## DETAILED DESCRIPTION OF THE INVENTION AND PREFERRED EMBODIMENTS

As used herein, "high refractive index" means a refractive index of about 1.50 or greater when measured at room temperature using a sodium lamp.

According to the present invention, foldable, acrylic, high refractive index ophthalmic device materials comprising one or more monomers having the structure of Formula I below are prepared using a blue-light source and a benzoyl-phosphine oxide initiator. First, an ophthalmic device material mixture comprising a benzoylphosphine oxide initiator a UV absorber and one or more compounds of Formula I below is prepared.



wherein: X is H or CH<sub>3</sub>;

m is 0-10;

Y is nothing, O, S, or NR wherein R is H, CH<sub>3</sub>, C<sub>n</sub>H<sub>2n+1</sub> (n=1-10) iso OC<sub>3</sub>H<sub>7</sub>, C<sub>6</sub>H<sub>5</sub>, or CH<sub>2</sub>C<sub>6</sub>H<sub>5</sub>;

Ar is any aromatic ring which can be unsubstituted or substituted with H, CH<sub>3</sub>, C<sub>2</sub>H<sub>5</sub>, n-C<sub>3</sub>H<sub>7</sub>, iso-C<sub>3</sub>H<sub>7</sub>, OCH<sub>3</sub>, C<sub>6</sub>H<sub>11</sub>, Cl, Br, C<sub>6</sub>H<sub>5</sub>, or CH<sub>2</sub>C<sub>6</sub>H<sub>5</sub>.

After the mixture is prepared, it is exposed to a blue-light source for a time sufficient to cure the device material.

Monomers of Formula I are known and include, but are not limited to: 2-phenoxyethyl acrylate, 2-phenylethylthio acrylate, 2-phenylethylamino acrylate, phenyl acrylate, benzyl acrylate, 2-phenylethyl acrylate, 3-phenylpropyl acrylate, 4-

phenylbutyl acrylate, 4-methylphenyl acrylate, 4-methylbenzyl acrylate, 2-2-methylphenylethyl acrylate, 2-3-methylphenylethyl acrylate, 2-4-methylphenylethyl acrylate, and the like, including their corresponding methacrylates. These acrylic/methacrylic monomers and others are disclosed in U.S. Patent No. 5,290,892, the entire contents of which are hereby incorporated by reference

Preferred monomers of Formula (I) are those where X is H; m is 2-4; Y is nothing or O; and Ar is phenyl. Most preferred are 2-phenylethyl acrylate, 2-phenoxyethyl acrylate, 3-phenylpropyl acrylate, 3-phenoxypropyl acrylate, 4-phenylbutyl acrylate, and 4-phenoxybutyl acrylate.

The exact amount of monomer of Formula I present in the foldable, acrylic, high refractive index ophthalmic device materials of the present invention will vary depending upon the identity of the monomer(s) of Formula I, the identity of any other device-forming monomer(s) present in the materials, and the desired mechanical properties. For example, foldable intraocular lenses are preferably made from polymers having a glass transition temperature no greater than normal room temperature, e.g., about 20 – 25 °C, in order that the lenses can be rolled or folded conveniently at room temperature. Glass transition temperature is determined at room temperature using a differential scanning calorimeter at a heating rate of 10°C/min. Additionally, materials exhibiting an elongation of at least 150% when measured at room temperature using an Instron tensile tester at a cross-head speed of 50 cm/min) are preferred for use in foldable intraocular lenses because such lenses must exhibit sufficient strength to allow them to be folded without fracturing. For foldable intraocular lens applications, polymers having an elongation of at least 200% are more preferred.

Materials containing less than about 50% (w/w) of monomers containing an aromatic moiety are generally not high refractive index materials. Thus, in general, the foldable, acrylic, high refractive index ophthalmic device materials of the present invention will contain at least 50% (w/w) of monomer(s) of Formula I. Preferably, the device materials will contain one or more monomers of Formula I

in an amount totaling 70% (w/w) or more, and most preferably, 80% (w/w) or more.

Device-forming monomers other than those of Formula I optionally may be included in the compositions of the present invention. Many such ophthalmic device-forming monomers are known. Any known device-forming monomer may be used if it is compatible with the monomer(s) of Formula I present in the composition and does not interfere with the ability of the benzoylphosphine oxide photoinitiator to cure the composition when exposed to blue light. Suitable device-forming monomers other than those of Formula I include, but are not limited to: C<sub>1</sub> - C<sub>8</sub> alkylacrylates, C<sub>1</sub> - C<sub>8</sub> cycloalkylacrylates, N-alkylacrylamides (where alkyl = C<sub>1</sub> - C<sub>4</sub>), phenoxyalkylacrylates (where alkyl = C<sub>1</sub> - C<sub>8</sub>), glycerylacrylate, polyethyleneoxide mono- and diacrylates, 2-hydroxyethylacrylates, and their corresponding methacrylates. Suitable device-forming monomers other than those of Formula I also include N-vinylpyrrolidone. See U.S. Patent No. 5,331,073, the entire contents of which are hereby incorporated by reference, for examples of device-forming materials containing one monomers of Formula 1 in combination with such suitable device-forming monomers.

As in the case of the monomer(s) of Formula I, the amount of any other device-forming monomers present in the ophthalmic device materials of the invention will vary depending upon the identity of the monomer(s) of Formula I, the identity of the optional device-forming monomer(s), and the mechanical properties desired for the polymerized ophthalmic material. In general, for foldable intraocular lens applications, the ophthalmic device materials of the present invention may contain about 45% (w/w) or less, and preferably about 30% (w/w) or less, of device-forming monomers other than those of Formula I.

Ultraviolet absorbing chromophores are also included in the ophthalmic device materials of the present invention. Such chromophores prevent or inhibit UV light from damaging the eye. In the case of intraocular lenses, UV absorbers



allow the light absorbance of an intraocular lens to approximate that of the eye's natural lens. The ultraviolet absorbing chromophore in the device material of the present invention can be any compound which absorbs light having a wavelength shorter than about 400 nm, but does not absorb any substantial amount of visible light, and which is compatible with the device-forming monomer(s) present in the material. The ultraviolet absorbing compound is incorporated into the monomer mixture and is entrapped in the polymer matrix when the monomer mixture is polymerized. Suitable ultraviolet absorbing compounds include substituted benzophenones, such as 2-hydroxybenzophenone, and 2-(2-hydroxyphenyl)-benzotriazoles. It is preferred to use an ultraviolet absorbing compound that is copolymerizable with the device-forming monomers described above so that it will be covalently bound to the polymer matrix. In this way, possible leaching of the ultraviolet absorbing compound out of the device and into the interior of the eye is minimized. Suitable copolymerizable ultraviolet absorbing compounds are the substituted 2-hydroxybenzophenones disclosed in U.S. Patent No. 4,304,895 and the 2-hydroxy-5-acryloxyphenyl-2H-benzotriazoles disclosed in U.S. Patent No. 4,528,311. The most preferred ultraviolet absorbing compound is 2-(3'-methallyl-2'-hydroxy-5'-methyl phenyl) benzotriazole.

In addition to the device-forming monomer(s) and the UV-absorber, the device materials of the present invention contain a benzoylphosphine oxide as a photoinitiator. Benzoylphosphine oxide initiators are known and are commercially available. Examples of benzoylphosphine initiators include 2,4,6-trimethyl-benzoyldiphenylphosphine oxide; bis-(2,6-dichlorobenzoyl)-4-N-propylphenylphosphine oxide; and bis-(2,6-dichlorobenzoyl)-4-N-butylphenylphosphine oxide. Most preferred is 2,4,6-trimethyl-benzoyldiphenylphosphine oxide, commercially available as Lucirin® TPO from BASF Corporation (Charlotte, North Carolina).

The amount of benzoylphosphine oxide initiator in the device materials of the present invention will depend upon the identity of the other ingredients in the materials, the light flux, and other processing conditions such as the desired curing time and the presence of inhibitors such as oxygen. In general, however,

the amount of benzoylphosphine oxide initiator will be about 3% or less, preferably about 2% or less, and most preferably about 1%.

Although not essential, the ophthalmic device materials of the present invention may optionally contain one or more copolymerizable cross-linking monomers. The use of cross-linking monomers is preferred. If desired, suitable cross-linking monomers include almost any terminally ethylenically unsaturated compound having more than one unsaturated group. Suitable cross-linking agents include, for example: ethyleneglycol dimethacrylate; diethylene glycol dimethacrylate; ethyleneglycol diacrylate; allyl methacrylates; allyl acrylates; 1,3-propanediol dimethacrylate; 1,6-hexanediol dimethacrylate; 1,4-butanediol dimethacrylate; polyethyleneoxide mono- and diacrylates; and the like. A preferred cross-linking agent is 1,4-butanediol diacrylate (BDDA). A preferred cross-linking agent is 1,4-butanediol diacrylate (BDDA). The amount of cross-linking agent generally will be less than about 10% (w/w) or less, preferably about 5% (w/w) or less.

Blue-light absorbing compounds are also optionally included in the device materials of the present invention. The blue-light absorbing compound, e.g. yellow dyes, should only be used in an amount at which they do not substantially interfere with the blue light source's ability to activate the benzoylphosphine oxide initiator. The presence of a blue-light absorber may necessitate an increased amount of benzoylphosphine oxide initiator. Preferably, blue-light absorbers are copolymerizable with the device-forming monomers. Suitable polymerizable blue-light blocking chromophores include those disclosed in U.S. Patent No. 5,470,932.

The device materials of this invention are prepared by forming a mixture of the device-forming monomer(s) (monomer(s) of Formula I and any optional device-forming monomer), the UV-absorbing chromophore, and the benzoylphosphine oxide initiator, along with any other suitable ingredients, in the desired proportions. The mixture can then be introduced into a mold of suitable shape to form an ophthalmic device, and the polymerization carried out by exposure to blue-light.

The device materials of the present invention are preferably cured in vitro.

Blue-light sources are commercially available and include: the Palatray CU blue-light unit (available from Heraeus Kulzer, Inc., Irvine, California), the Fusion F450 blue light system (available from TEAMCO, Richardson, Texas) and the GE 24" blue fluorescent lamp (available from General Electric Company, U.S.). A preferred blue-light source is the Palatray CU blue-light unit. Suitable blue-light sources emit light in the 400 - 500 nm range sufficient to activate benzoylphosphine oxide initiators. Suitable blue-light sources include sunlight and standard white fluorescent light bulbs, for example, though these sources would require longer exposure times to achieve complete cures than sources which emit light in the 400 - 500 nm range at higher intensities.

The intensity of the blue light from the blue-light source is preferably from about 1 to about 40 mW/cm<sup>2</sup>. An intensity in the blue-light region of from about 10 to about 15 mW/cm<sup>2</sup> is more preferred. If the intensity of blue-light is too great, in addition to shrinkage problems created during curing, the device material may turn yellow or otherwise become discolored.

The length of time necessary for the device materials of the present invention to be exposed to a blue light source in order to be cured will depend upon a variety of factors, including the reactivity of the device material ingredients, the size and mass of the sample to be cured, the initiator concentration and the intensity of the blue-light source. In general, for individually cast devices, exposure times will range from about 5 minutes to about 4 hours, preferably from about 15 minutes to about 2 hours. Attempting to cure the materials too quickly may result in compromised optical properties; too rapid cross-linking may cause shrinkage-related stresses within the cured polymer that distort the surface of the device as they are relieved.

For exposure times of about an hour or less, it is preferred that the molds containing the device materials not be opened immediately after being exposed to

blue-light. Leaving the molds unopened for approximately one hour allows residual curing reactions to be completed.

The ophthalmic device materials prepared according to the present invention  
5 may be used to make almost any type of ophthalmic lens, including contact lenses, intracorneal lenses and intraocular lenses. Ophthalmic lenses constructed of the disclosed materials can be of any design, but are preferably intraocular lenses (IOLs) capable of being rolled or folded and inserted through a relatively small incision. For example, the IOLs can be of what is known as a one piece or  
10 multipiece design. Typically, an IOL comprises an optic and at least one haptic. The optic is that portion which serves as the lens and the haptics are attached to the optic and are like arms that hold the optic in its proper place in the eye. The optic and haptic(s) can be of the same or different material. Haptics may be attached to the optic using conventional techniques. In a single piece lens, the  
15 optic and the haptics are formed out of one piece of material. Depending on the material, the haptics are then cut, or lathed, out of the material to produce the IOL. In addition to ophthalmic lenses, the materials prepared according to the methods of the present invention may also be used to make other ophthalmic devices including, but not limited to, keratoprotheses and corneal inlays or rings.

20

Molding and drilling operations are easily carried out if the device, e.g., an IOL optic, is molded between two polypropylene mold halves. The mold containing the cured device material is then placed on a lathe and the desired shape is lathe cut. The mold may then be easily mounted to carry out any drilling operations prior  
25 to removing the mold halves. Both the lathing and drilling operations may be facilitated by cooling the mold/device in a freezer to less than 10°C and preferably less than 0°C prior to each of these operations. If premature release of one or both mold halves occurs, it may be necessary to use clamps or alternative mold materials or to treat the surface of the mold halves.

30

The invention will be further illustrated by the following examples which are intended to be illustrative, but not limiting.

EXAMPLES

The following mixtures shown below in Table 1 were prepared and  
5 transferred into molds for curing:

Table 1\*

	1	2	3	4	5	6	7	8	9	10	11	12	13	14
PEA							65	80						
PEMA						100	30							
MMA					100									
HEMA	99							15						
POEA									89.6		89.5	87.8		87.7
HA									10	99.65	5	10	97.8	5
NVP		75	100								5			5
STYRENE		25		100										
EGDMA									0.35	0.35	0.35	0.35	0.35	0.35
BDDA	1	1					3.2	3.2						
OMTP							1.8	1.8				1.8	1.8	1.8

PEA = 2-phenylethylacrylate

PEMA = 2-phenylethylmethacrylate

MMA = methyl methacrylate

HEMA = 2-hydroxyethylmethacrylate

POEA = 2-phenoxyethyl acrylate (passed through basic alumina)

HA = N-hexyl acrylate (passed through basic alumina)

NVP = N-vinyl pyrrolidone (passed through acidic alumina)

EGDMA = ethyleneglycoldimethacrylate

BDDA = 1,4-butanediol diacrylate

OMTP = o-Methyl Tinuvin P (2-(3'-methallyl-2'-hydroxy-5'-methyl phenyl)-benzotriazole)

\*All values are expressed as parts by weight.

The compositions of Examples 1 - 14 were then cured according to each of three cure profiles as indicated below in Table 2: a thermal cure system using the thermal initiator Perkadox 16 and a curing temperature of 70 °C for 1 hour; and two photoinitiators, camphorquinone and Lucirin® TPO, respectively, using a blue-light source with exposure times of 15, 30 and 60 minutes. After completing the cure profile, all molds were left unopened for approximately 1 hour. After opening the molds, physical appearance was recorded. "Liquid" indicates that the sample did not appear to cure to any significant extent. "Gel-slime" indicates that the sample cured to some extent, but still appeared to be primarily a liquid. "Gel" indicates that the sample cured to a loose solid. "Solid" indicates that the sample appeared to cure thoroughly or completely.

After the physical appearance of each sample was recorded, the samples rated "solid" were extracted in acetone. These samples were weighed ("initial weight"), placed into hot (near boiling) acetone for two hours, and then dried for two hours in an air-circulating oven. After drying, the samples were weighed again ("final weight"). The percent extractables were calculated as follows:  $(\text{initial weight} - \text{final weight}) / (\text{initial weight}) \times 100$ . For samples rated "liquid," no weight measurements were taken; % extractables for these samples was estimated to be 100%. For samples rated "Gel-slime" or "Gel" no weight measurements were taken; % extractables for these samples was estimated to be > 95%. The physical appearance and the level of extractables for each of the samples of Table 1 are shown below in Table 2.

TABLE 2

Cure Profile	1 hr/70C oven	15 / 30 / 60 min 14 mW/cm <sup>2</sup> blue light	15 / 30 / 60 min 14 mW/cm <sup>2</sup> blue light
Initiator (concentration)	Perkadox-16 (1%)	dl-Camphorquinone (0.5%)	Lucirin® TPO (0.5%)
Example #	Cure Results		
1	solid	gel-slime/gel-slime/ solid	solid/ solid/ solid
2	liquid	liquid/liquid/liquid	liquid/liquid/liquid
3	liquid	gel/gel/gel	solid/ solid/ solid
4	liquid	liquid/liquid/liquid	liquid/liquid/liquid
5	solid	liquid/liquid/liquid	liquid/liquid/liquid
6	solid	liquid/liquid/gel	solid/ solid/ solid
7	solid	solid/ solid/ solid	solid/ solid/ solid
8	solid	gel/gel/solid	solid/ solid/ solid
9	solid	solid/ solid/ solid	solid/ solid/ solid
10	solid	gel/gel/gel	gel/gel/gel
11	solid	solid/ solid/ solid	solid/ solid/ solid
12	solid	solid/ solid/ solid	solid/ solid/ solid
13	solid	liquid/liquid/liquid	gel/gel/gel
14	solid	solid/ solid/ solid	solid/ solid/ solid
% ACETONE EXTRACTABLES*			
EXAMPLE #			
1	<1	> 95	> 95
2	100	100	100
3	100	ND	ND
4	100	100	100
5	8.0	100	100
6	0.9	100	ND
7	8.5	ND	18.8
8	6.7	>95	>95
9	8.6	6.2	6.6
10	9.2	>95	>95
11	7.5	6.8	5.5
12	20.4	48.3	22.2
13	13.2	100	100
14	21.5	46.1	35.1

\*ND = not determined

5 The results of Table 2 are discussed with reference to the type of device-forming monomer(s) present in the samples:

**a) Aryl (meth)acrylate based polymers (Examples 6 - 9, 11, 12, and 14)**

10 When the samples lacked an UV-absorber (Examples 9 and 11), they cured similarly in the presence of either blue-light initiator, camphorquinone ("CQ") or Lucirin® TPO ("TPO"), with the TPO-cured samples showing somewhat lower



extractables. In contrast, when the samples contained an UV-absorber (Examples 6 - 8, 12 and 14), the CQ initiator gave much poorer results: in all such cases, the extractables were significantly higher for the samples cured with CQ than with TPO.

**b) Alkyl (meth)acrylate based polymers (Examples 5, 10 and 13)**

Although the samples of Examples 5, 10 and 13 all cured to some extent when the thermal initiator was used, all of these samples cured very poorly when either CQ or TPO was used as an initiator. The poor performance of the CQ and TPO initiators in these samples was consistent irrespective of the presence or absence of an UV absorber.

**c) Hydroxyalkyl methacrylate polymers (Example 1)**

The TPO-initiated system cured very well even after the shortest exposure time (15 minutes), while the CQ-initiated system did not cure well until one hour of exposure - and even at this exposure, extractables were three times higher than the TPO-cured system at the shortest exposure time. 2-Hydroxyethyl methacrylate (HEMA) is typically rapidly cured - yet the CQ-initiated system still gave a sluggish cure.

**d) Vinyl monomers (Examples 2 - 4)**

Neither the styrene (Ex. 4) nor the NVP/styrene samples (Ex. 2) cured well with any of the initiators. The NVP sample (Ex. 3) appeared to cure poorly with CQ but well with TPO. The NVP sample apparently dissolved when extracted with acetone, however. It is presumed that this result may be explained by a non-cross-linked nature of the polyvinylpyrrolidone.

The superior results obtained with TPO are surprising in view of the fact that CQ has a greater absorbency in the blue-light region than does TPO (see

Figures 1 and 2), and thus would be expected to have the higher activity. Additionally, with reference to Fig. 3 which shows the UV-visible spectrum of the UV-absorber used in the Examples, the fact that TPO gave results superior to CQ in the presence of the UV-absorber is surprising. The absorption bands for the UV-chromophore (oMTP) and CQ are well separated (compare Figs. 2 and 3),  
 5 whereas there is appreciable spectral overlap between the oMTP and TPO compounds (compare Figs. 1 and 3). Thus, the UV-chromophore would be expected to interfere significantly with the ability of TPO to be activated by the light source, but not CQ. The opposite was observed (Compare Examples 9 and  
 10 11 with Examples 12 and 14).

The effect of cure time and radiation flux on the level of extractables and mechanical properties was examined for the composition of Example 7. In all cases, the concentration of the photoinitiator was 0.4%. This level of photoinitiator  
 15 was chosen because discoloring (yellowing) was observed at greater concentrations of CQ initiator. The results are shown below in Table 3.

TABLE 3

Lamp*/Cure Time	% Extractables		%AU**	IOL/slab		Stress		Modulus	
	CQ	TPO		Tg		psi	%Strain	psi	
GE-15 min	~ 100	10.7	51.1	12.2/12.7		878	629	224	
GE-30 min	~ 100	2.9	44.9	12.3/12.2		979	618	229	
GE-60 min	~ 100	1.8	45.1	12.8/12.2		1014	611	266	
CU-15 min	~ 100	4.3	46.6	11.8		908	657	232	
CU-30 min	~ 100	1.9	46.6	11.8		975	654	250	
CU-60 min	40.6	1.5	45.6	12.9		1077	676	269	
CU-120 min	10.4	---	---	---		---	---	---	

\*Lamp: GE = GE 20 watt/24" blue fluorescent lamp; CU = Heraeus Kulzer Palatray CU blue-light unit

20 \*\*AU = weight percent of acetone uptake: slabs placed overnight in acetone (room temperature), then patted dry and weighted on WR-129 Mettler scale within 15 seconds.

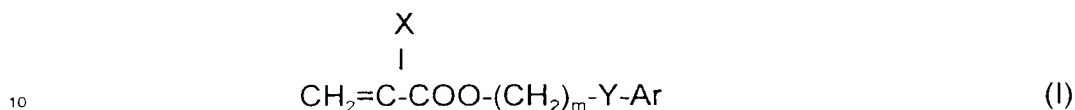
To evaluate the relative reactivity of TPO and CQ initiators, Example #7 was prepared using a 0.4% (w/w) level of each initiator. The 0.4% concentration for the initiator was selected based on the fact that the use of higher levels with CQ resulted in color formation and increased levels of extractables; the range of CQ reported in the literature is typically 0.1% to 0.5%. Two radiation fluxes were used: 3 and 14 mW/cm<sup>2</sup>. The 3 mW/cm<sup>2</sup> intensity was produced by the GE 20 watt, blue fluorescent lamp; the 14 mW/cm<sup>2</sup> intensity was produced by the Palatray CU blue-light unit. The level of acetone extractables and mechanical properties were measured as a function of flux and cure time. Based on extractable levels, it took the CQ more than 37 times longer to achieve the same level as TPO ( i.e., 15 min/3 mW for TPO = 120 min/14 mW/cm<sup>2</sup> for CQ). After 60 minutes @ 14m W/cm<sup>2</sup> the CQ initiated monomer still gave more than 40% extractables. The TPO initiated system, on the other hand, achieved near optimal extractable levels (< 5%) after less than a 30-minute exposure at 3 mW/cm<sup>2</sup>. These results are surprising in light of the fact that the CQ has the greater absorption in the blue light region of the spectrum.

The invention having now been fully described, it should be understood that it may be embodied in other specific forms or variations without departing from its spirit or essential characteristics. Accordingly, the embodiments described above are to be considered in all respects as illustrative and not restrictive, the scope of the invention being indicated by the appended claims rather than by the foregoing description, and all changes which come within the meaning and range of equivalency of the claims are intended to be embraced therein.

## WE CLAIM:

1. A method of preparing a foldable, acrylic, high refractive index ophthalmic device material comprising the steps of:

- 5 a) preparing a device-forming mixture of a benzoylphosphine oxide photoinitiator, a UV-absorbing chromophore and one or more device-forming monomers having the structure (I)



where X is H or CH<sub>3</sub>;

m is 0-10;

Y is nothing, O, S, or NR wherein R is H, CH<sub>3</sub>, C<sub>n</sub>H<sub>2n+1</sub> (n=1-10) iso OC<sub>3</sub>H<sub>7</sub>, C<sub>6</sub>H<sub>5</sub>, or CH<sub>2</sub>C<sub>6</sub>H<sub>5</sub>; and

15

Ar is any aromatic ring which can be unsubstituted or substituted with H, CH<sub>3</sub>, C<sub>2</sub>H<sub>5</sub>, n-C<sub>3</sub>H<sub>7</sub>, iso-C<sub>3</sub>H<sub>7</sub>, OCH<sub>3</sub>, C<sub>6</sub>H<sub>11</sub>, Cl, Br, C<sub>6</sub>H<sub>5</sub>, or CH<sub>2</sub>C<sub>6</sub>H<sub>5</sub>;

and

- 20 b) exposing the mixture to a blue-light source for a period of time sufficient to cure the device material.

2. The method of Claim 1 wherein the monomer of structure (I) is selected from the group consisting of: 2-phenoxyethyl acrylate; 2-phenylethylthio acrylate; 2-phenylethylamino acrylate; phenyl acrylate; benzyl acrylate; 2-phenylethyl acrylate; 3-phenylpropyl acrylate; 4-phenylbutyl acrylate; 4-methylphenyl acrylate; 4-methylbenzyl acrylate; 2-2-methylphenylethyl acrylate; 2-3-methylphenylethyl acrylate; 2-4-methylphenylethyl acrylate; and their corresponding methacrylates.

25

30 3. The method of Claim 1 wherein X is H; m is 2-4; Y is nothing or O; and Ar is phenyl.

4. The method of Claim 3 wherein the monomer of structure (I) is selected from the group consisting of: 2-phenylethyl acrylate; 2-phenoxyethyl acrylate; 3-phenylpropyl acrylate; 3-phenoxypropyl acrylate; 4-phenylbutyl acrylate; and 4-phenoxybutyl acrylate.

5. The method of Claim 1 wherein the device material has a glass transition temperature no greater than 25 °C and an elongation of at least 150%.

6. The method of Claim 1 wherein the total amount of monomer of structure (I) present in the device material is at least 50% (w/w).

7. The method of Claim 6 wherein the total amount of monomer of structure (I) present in the device material is at least 70% (w/w).

8. The method of Claim 7 wherein the total amount of monomer of structure (I) present in the device material is at least 80% (w/w).

9. The method of Claim 6 wherein the device-forming mixture further comprises one or more additional device-forming monomers selected from the group consisting of: C<sub>1</sub>-C<sub>8</sub> alkylacrylates; C<sub>1</sub>-C<sub>8</sub> cycloalkylacrylates; N-alkylacrylamides (where alkyl = C<sub>1</sub>-C<sub>4</sub>); phenoxyalkylacrylates (where alkyl = C<sub>1</sub>-C<sub>8</sub>); glycerylacrylate; polyethyleneoxide mono- and diacrylates; 2-hydroxyethylacrylate; C<sub>1</sub>-C<sub>8</sub> alkylmethacrylates; C<sub>1</sub>-C<sub>8</sub> cycloalkylmethacrylates; N-alkylmethacrylamides (where alkyl = C<sub>1</sub>-C<sub>4</sub>); phenoxyalkylmethacrylates (where alkyl = C<sub>1</sub>-C<sub>8</sub>); glycerylmethacrylate; polyethyleneoxide mono- and dimethacrylates; 2-hydroxyethylmethacrylate; and N-vinylpyrrolidone.

10. The method of Claim 10 wherein the total amount of additional device-forming monomer is 45% (w/w) or less.

11. The method of Claim 1 wherein the benzoylphosphine oxide initiator is selected from the group consisting of: 2,4,6-trimethyl-benzoyldiphenylphosphine

oxide; bis-(2,6-dichlorobenzoyl)-4-N-propylphenyl-phosphine oxide; and bis-(2,6-dichlorobenzoyl)-4-N-butylphenylphosphine oxide.

12. The method of Claim 11 wherein the benzoylphosphine oxide initiator is 2,4,6-trimethyl-benzoyldiphenylophosphine oxide.

13. The method of Claim 1 wherein the amount of benzoylphosphine oxide initiator is less than about 3% (w/w).

14. The method of Claim 13 wherein the amount of benzoylphosphine oxide initiator is about 1% (w/w).

15. The method of Claim 1 wherein the device-forming mixture further comprises one or more copolymerizable cross-linking monomers.

16. The method of Claim 1 wherein the blue-light source has an intensity of from about 1 to about 40 mW/cm<sup>2</sup> and the period of time in which the device-forming mixture is exposed to the blue-light source is from about 5 minutes to about 4 hours.

17. The method of Claim 1 wherein the blue-light source has an intensity of from about 10 to about 15 mW/cm<sup>2</sup>.

18. The method of Claim 1 wherein the device-forming mixture comprises 2-phenylethyl acrylate and 2-phenylethyl methacrylate.

19. The method of Claim 1 wherein the device-forming mixture comprises 2-phenylethyl acrylate and 2-hydroxyethyl methacrylate.

20. The method of Claim 1 wherein the device-forming mixture comprises phenoxyethyl acrylate and N-hexyl acrylate.

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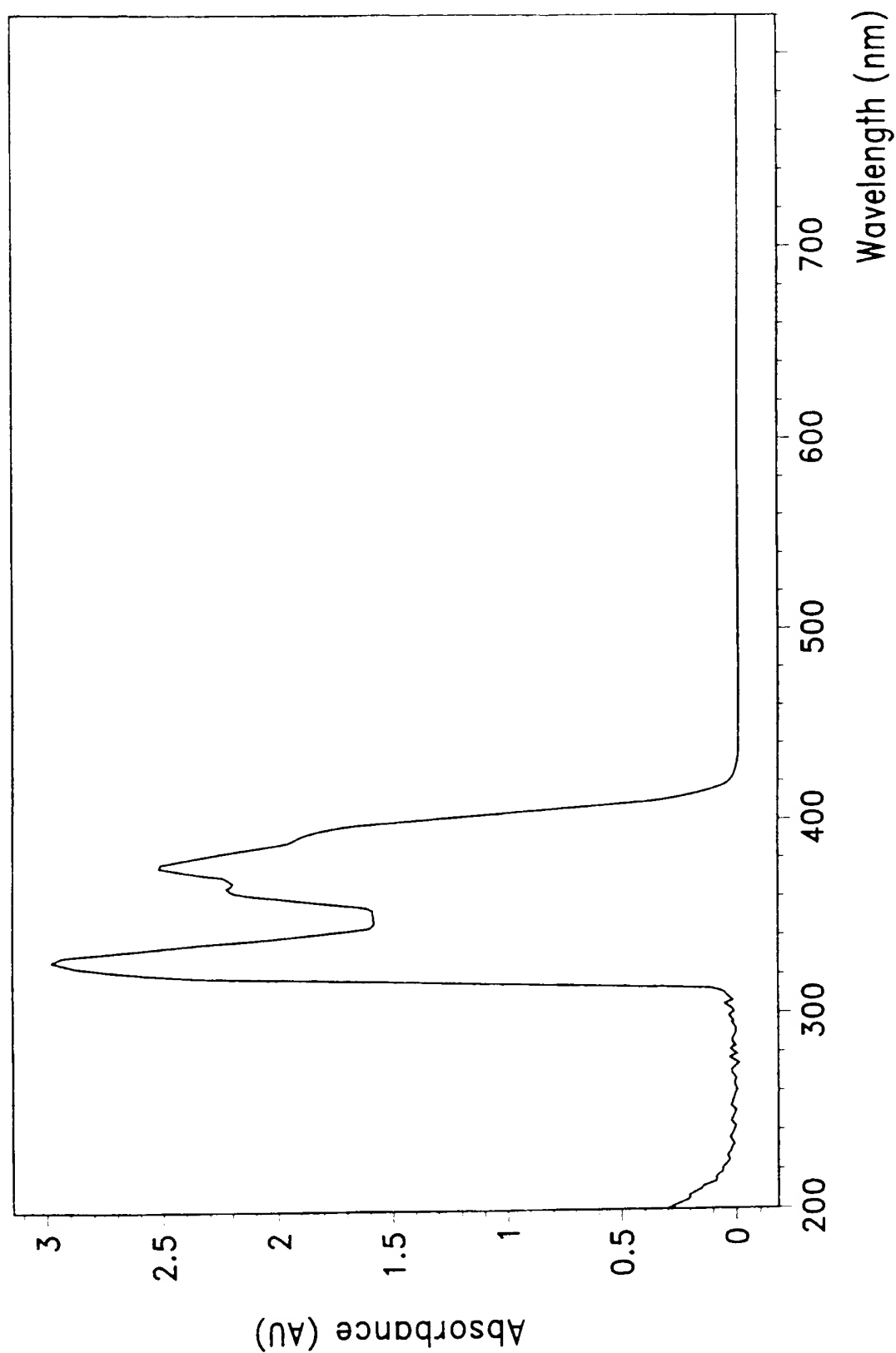


FIG. 1

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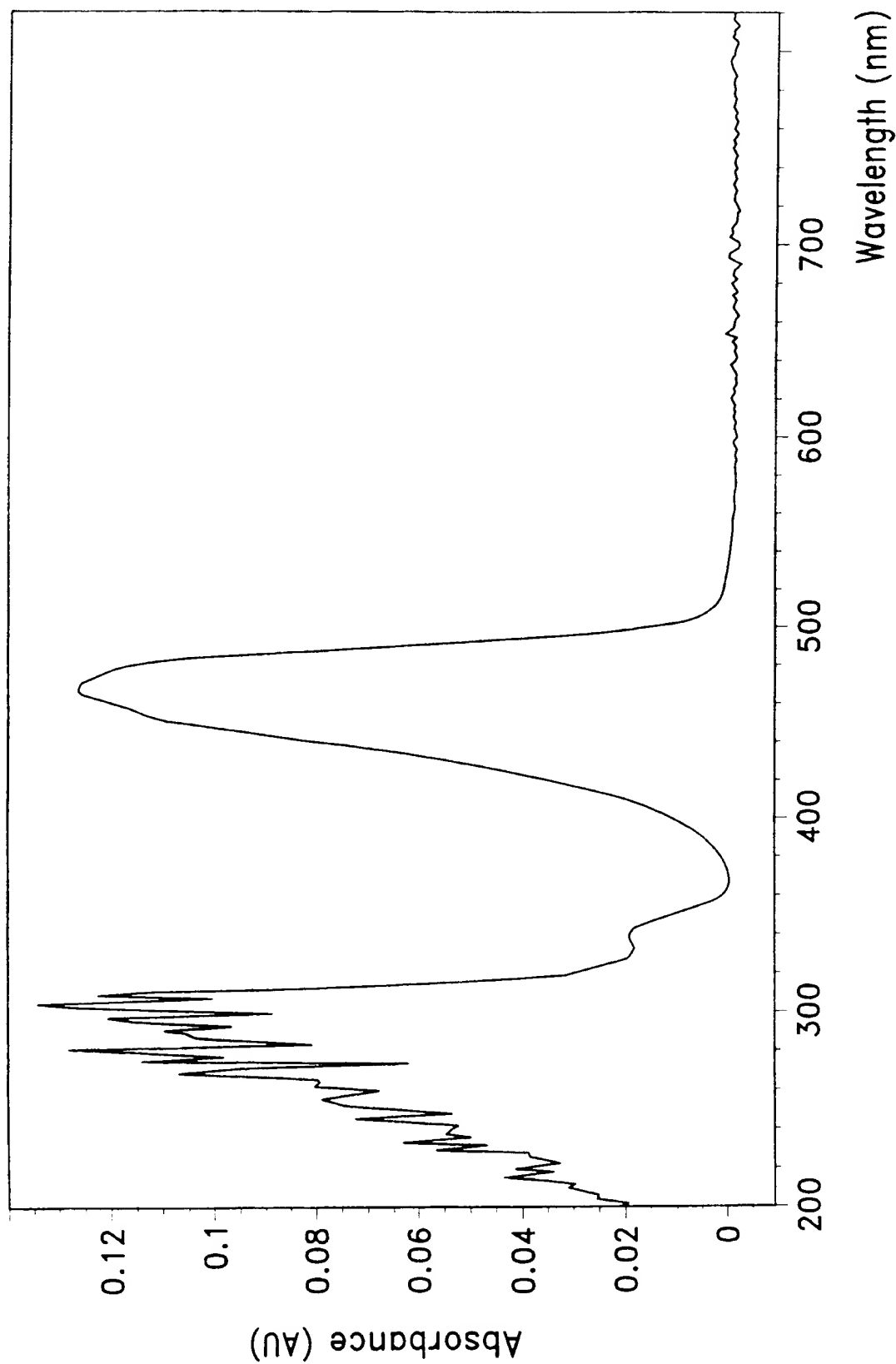


FIG. 2

SUBSTITUTE SHEET (RULE 26)



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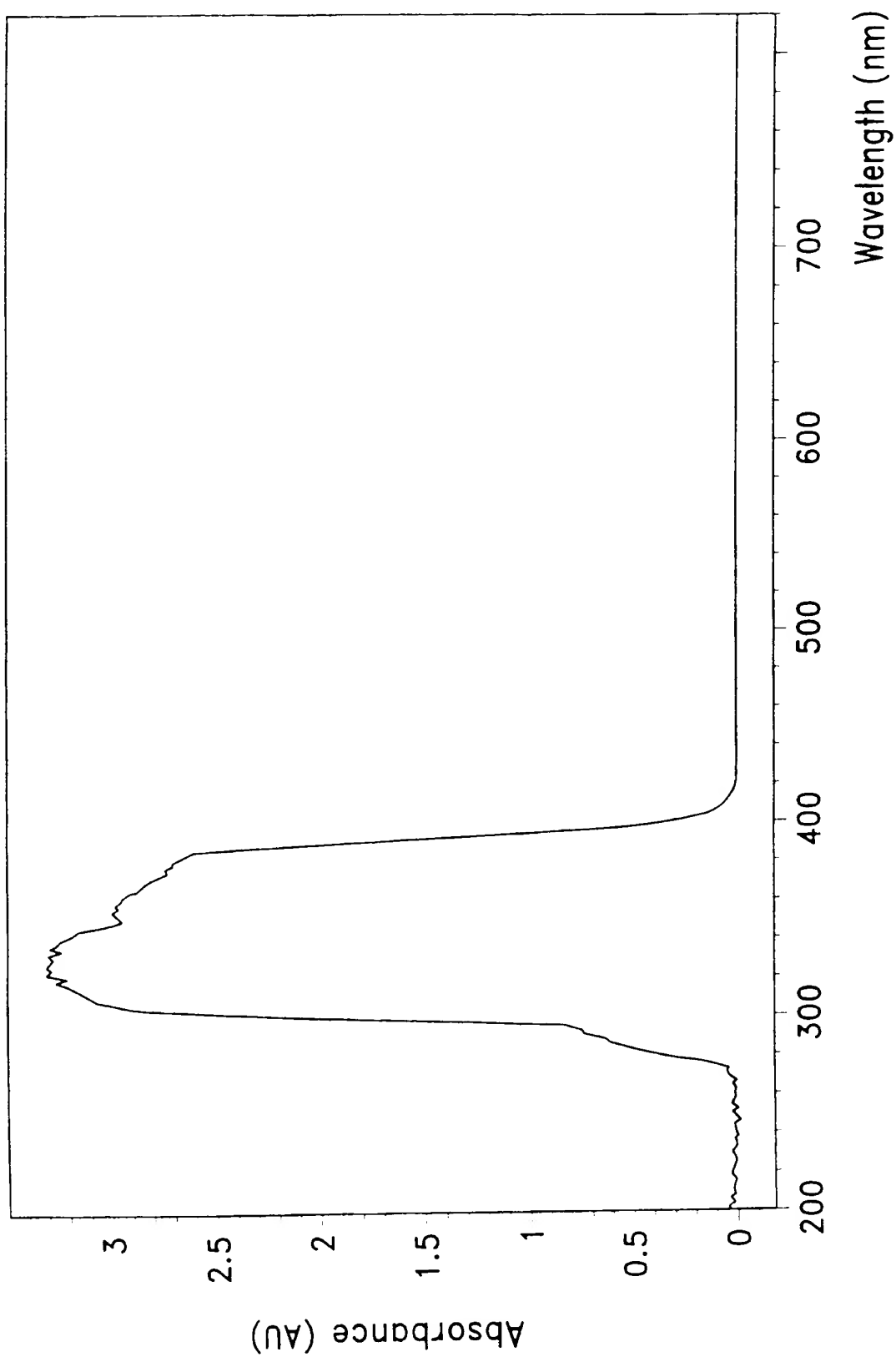


FIG. 3

# INTERNATIONAL SEARCH REPORT

International Application No.

PCT/US 98/14419

## A. CLASSIFICATION OF SUBJECT MATTER

IPC 6 G02B1/04 A61L27/00 C08F2/50 C08F20/18

According to International Patent Classification (IPC) or to both national classification and IPC

## B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 6 G02B A61L C08F

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

## C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No
A	WO 96 40303 A (ALCON LAB INC) 19 December 1996 see claims 1,4,5,7,9,14,15,21,22 ---	1
A	US 5 290 892 A (NAMDARAN FARHAD H ET AL) 1 March 1994 cited in the application see claims 1,4 see column 2, line 15 - line 39 see column 4, line 50 - column 5, line 22 ---	1
A	EP 0 485 197 A (NESTLE SA) 13 May 1992 see claims 1,5,6,8-12 see page 4, line 14 - line 20 see page 4, line 31 - line 51 ---	1
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Further documents are listed in the continuation of box C



Patent family members are listed in annex

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Date of the actual completion of the international search

19 October 1998

Date of mailing of the international search report

28/10/1998

Name and mailing address of the ISA

European Patent Office - P.B. 5518 Patentlaan 2  
NL - 2280 HV Rijswijk  
Tel. (+31-70) 340-2040 Tx 31 651 epo nl  
Fax (+31-70) 340-3010

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# INTERNATIONAL SEARCH REPORT

International Application No.  
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Category	Citation of document, with indication where appropriate, of the relevant passages	Relevant to claim No.
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A	EP 0 445 570 A (GEN ELECTRIC) 11 September 1991 see claim 1 see page 3, line 3 - line 7 -----	1

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